

SPLIT-1




## Work Order ID 70978 -1



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Monday, June 20, 2011 2:47:06 PM

Item ID: D6101-003 Accept  Setup Start   
 Revision ID:  
 Item Name: Saddle Billet, 7075 Stop   
 Start Date: 6/20/2011 Start Qty: 30.00  Cust Item ID:  
 Required Date: 6/23/2011 Req'd Qty: 30.00  Customer:  
 Reference:

Approvals: Process Plan:  Date: 6-20-2011 Tooling: Date:  
 QC: Date: SPC (Y/N): Date:  
 Run Start   
 Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D6101	Rev B

100  PURCHASING 0.00  
 Purchasing  0.00  
 Purchasing

## Memo

Issue P/O:

14341

- a) Description: Aluminum billet  
 b) 7.875" x 6.250" x 2.00" thick  
 c) Tolerance on all dimensions are +0.030"/-0.000"  
 d) Grain direction along 7.875" length  
 e) Material: 7075-T7351 (QQ-A-250/12)  
 f) Material certification required

CL 11/06/22 30

110  Receive & Inspect for Damage & Mat'l Certs 0.00  
 Packaging  0.00  
 Packaging

## Memo

Ensure material certification is attached

CL 11/06/24 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 70978**

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Monday, June 20, 2011 2:47:06 PM

Item ID: D6101-003

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Billet, 7075

Start Date: 6/20/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D6101

SA 11/7/15

20



130

Identify as per dwg &amp; Stock Location: CWC

0.00



Packaging

Memo

0.00

Packaging

SA 11/7/15

20



140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/15

MF 11-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, June 20, 2011 2:47:13 PM

Page 1

Work Order ID: 70978



Parent Item: D6101-003



Parent Item Name: Saddle Billet, 7075


Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP A: ☐01.05.04 ☐New Issue ☐EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003P  7075-T7351 2X6.25X7.875		Purchased	No			110	Each	0.0000	1	30			



C24/06/24 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

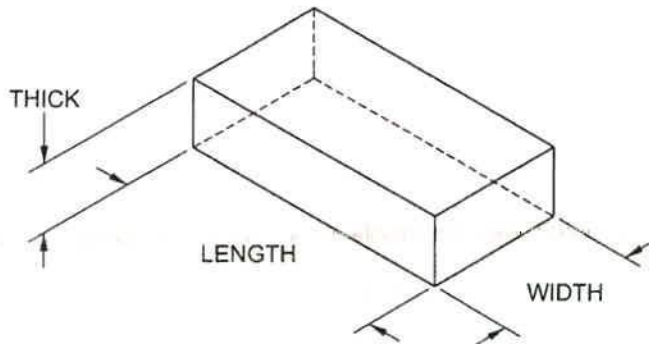
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# SPECIFICATION CONTROL DRAWING



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70978  
*PH 11-de-20*

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

B

RELEASED  
*09/07/15/WB*

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Castle Metals®**

A. M. Castle &amp; Co.

**PACKING SLIP**

Page 1 of 1

Shipment No:865320

<b>Ship From:</b> A. M. Castle & Co. (Canada) Inc. MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		<b>Sold To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		<b>Ship To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		<b>Deliver To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
<b>Date Shipped</b>	<b>F.O.B.</b>	<b>Freight Terms</b>		<b>Carrier</b>		<b>BOL No</b>	
23-JUN-2011	ORIGIN	Prepaid		MANITOULIN		865320-2	

<b>Shipment Details</b>	<b>Final Destination Branch - MON</b>
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Order No	Line No	Item No	Description				
1495487	1	752237.MO	2.0000.PL.7075.T7351.ALUMINUM.USI.48.5000.144.5000 CUT 2SIDED TO 6.25 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 7.875")) X 7.875 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 7.875")) - ALUMINUM PLATE SAW SPECIFICATIONS: QQ-A-250/12				
Purchase Order No		Part Number		Ordered Qty		Invoice Qty	
PER RELEASE 14341		YOUR ITEM NUMBER: D6101-003 ✓		20 PCS ✓ C211106/24		20 PCS ✓	
Details		DO NOT SHIP - HOLD FOR RELEASE					
Delivery No.	Mill	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)
82062333		506772A3		20			203.22

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:	Date:
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**KAISER  
ALUMINUM**

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

**CERTIFIED TEST REPORT**

Serial Number  
4193016

**ALLOY LIMITS**

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

**TEST NOTES**

7075-T7351 plate 3.501-4.000" thick, if  
ultrasonically inspected, meets requirements of CMMP025 per  
SDR CMMP025-KaiserT-3. 7075-T7351 plate 4.001-5.000" thick,  
if ultrasonically inspected, meets requirements of CMMP025  
per  
SDR CMMP025-KaiserT-2.

Metal represented by this test report was immersion  
ultrasonically tested from one side and meets the Class A  
and Class B requirements of all specifications referenced  
on this test report.

**Castle Metals FP**

HEAT NUMBER 506772 A3  
MECHANICAL ID \_\_\_\_\_  
ITEM CODE 6857  
LOT NUMBER \_\_\_\_\_  
PO NUMBER 45811  
RECEIPT DATE 5-11-2010  
SUPPLIER KAISER  
SPECIFICATION \_\_\_\_\_  
LCS NO  
COMMENT \_\_\_\_\_  
APPROVED BL

**CERTIFICATION**

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE UNITED STATES OF AMERICA OR A QUALIFYING COUNTRY PER DFARS 225.872-1(b), WAS MANUFACTURED IN THE UNITED STATES OF AMERICA, AND MEETS THE REQUIREMENTS OF DFARS 252.225 FOR DOMESTIC CONTENT. THIS MATERIAL HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED.

BILL POYNOR, LABORATORIES SUPERVISOR

*Bill Poy*



## SHIP TO:

A M CASTLE & CO  
3400 NO. WOLF ROAD  
FRANKLIN PARK, IL 60131

# KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

## SOLD TO:

AM CASTLE & CO- SOLD TO  
3400 NO. WOLF ROAD  
FRANKLIN PARK, IL 60131

## CERTIFIED TEST REPORT

Serial Number

4193016

CUSTOMER PO NUMBER: 45811		WORK PACKAGE:	CUSTOMER PART NUMBER: 6857 AMC A97075-160		SHIP RUN/LOAD: 101791/19	GOV'T CONTRACT NUMBER:
KAISER ORDER NO: 1096361	LINE ITEM: 1	SHIP DATE: 7-MAY-2010	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: Sawed Plate
WEIGHT SHIPPED: 8224 LB	QUANTITY: 6 PCS EST.	B/L NUMBER: 2027222	GAUGE: 2.0000 IN	DIAMETER/WIDTH: 48.500 IN	LENGTH: 144.500 IN	

## Certified Specifications

AMS 4078/RevG  
ASTM B 209/Rev07  
BSS 7055/RevA  
DPS 4.713/RevAH  
MMS 159/RevN

AMS-QQ-A-250/12  
ASTM B 594/Rev06  
CMMP 025/RevS  
GAMPS 9101/RevB  
PS 21211/RevK

AMS-STD-2154  
BAC 5439/RevH  
CSTI 006/RevC  
GSS16100/RevG/Amd1

Test Code: 4297

## Test Results

Lot: 506772A3 Cast 314

Drop 04

Ingot 2

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	72.5 : 72.6 (500 : 501)	61.3 : 61.8 (423 : 426)	12.5 : 13.3

(ASTM E1004)

(EN 2004-1)

Conductivity %IACS :	41.3 Min	41.9 Max
(MS/M) :	24.0 Min	24.3 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.09	0.17	1.4	0.04	2.4	0.20	5.5	0.04	0.01	0.01	TOT 0.05